

Work Order ID 58348

Monday, May 03, 2010 3:11:29 PM



Page 1

Item ID: D3303-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 5/4/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3303

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

B
B

0.00

FLOW CNC Waterjet

10-5-4



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-5-4

120

0.00



QC8- Inspect parts - second check

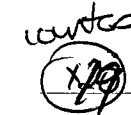
QC

Memo

0.00

Quality Control

S. Slosky



Pho →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-3 PAR #: _____ Fault Category: Small Part NCR: Yes No DQA: 7/2 Date: 10/05/05
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7/2 Date: 10/05/10

NCR: <u>58348</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/5/14</u>	<u>4</u> <u>110</u>	<u>Qty +1 Part Found with</u> <u>A loose screw in unit</u> <u>E.C. handling mat - not w/3</u>	<u>[Signature]</u> <u>05/04/14</u>	<u>-Screw And Dusty screw</u> <u>no Re-line</u> <u>extra made</u>	<u>[Signature]</u> <u>10/05/04</u>	<u>[Signature]</u> <u>10/05/05</u>	<u>[Signature]</u> <u>05/04/14</u>	<u>[Signature]</u> <u>10/05/09</u>

NOTE: Date & initial all entries

Work Order ID 58348

Monday, May 03, 2010 3:11:29 PM



Page 2

Item ID: D3303-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 5/4/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr 2- C'sink nut plate holes as per Dwg D3303 3-polish waterjet marks								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3303 to fit DT9011								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EP 5/05/04 (192)

SB 10/05/04

19

Siolostos

(19)

Work Order ID 58348

Monday, May 03, 2010 3:11:29 PM

Page 3

Item ID: D3303-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 5/4/2010 Start Qty: 15.00

Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 15.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

(19)

BL 10-5-6

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JL 10/05/06

19

Ø

180

Identify as per dwg & Stock Location: 185

0.00



Packaging

Memo

0.00

Packaging

10-5-6 sl

Work Order ID 58348

Monday, May 03, 2010 3:11:29 PM

Page 4

Item ID: D3303-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 5/4/2010 Start Qty: 15.00

Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 15.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10 *[Signature]*
MF
10-5-7.

Picklist Print

Monday, May 03, 2010 3:11:29 PM

Work Order ID: 58348



Parent Item: D3303-3



Parent Item Name: Bracket

Start Date: 5/4/2010

Required Date: 5/7/2010

Comments: IPP: ☐A☐04.09.07☐New issue☐KJ/JLM☐
IPP Rev:B 08-05-13 add DT9011 jig DD verified by:EC

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	506.7000	0.2986	4.5		



RB 10-5-4

2024-T3 .040 sheet

Location	Loc Qty	Loc Code
MAT	96	
114415	96	
MAT22	410.7	
110305	136.7	
111786	18	
112291	32	
112331	64	
113162	160	

113162

20

DART AEROSPACE LTD		Work Order: 58348
Description: Head Rest		Part Number: D3303-3
Inspection Dwg: D3303	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.850	+/-0.010	4.850	✓			
4.330	+/-0.005	4.330	✓			
0.550	+/-0.010	.548	✓			
0.260	+/-0.010	.262	✓			
3.300	+/-0.010	3.300	✓			
1.500	+/-0.005	1.504	✓			
0.250	+/-0.005	.247	✓			
Ø0.219	+0.005/-0.000	.222	✓			
Ø0.098	+0.005/-0.000	.102	✓			
Ø0.128	+0.005/-0.000	.132	✓			
R0.12	+/-0.030	.12	✓			
2.000	+/-0.005	2.000	✓			
1.425	+/-0.010	1.426	✓			
8.100	+/-0.010	8.102	✓			
1.000	+/-0.005	.999	✓			
0.040	+/-0.010	.040	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-5-4	Date: 10/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	
B	08.05.07	Dimensions updated per Dwg Rev B	KJ/DD	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

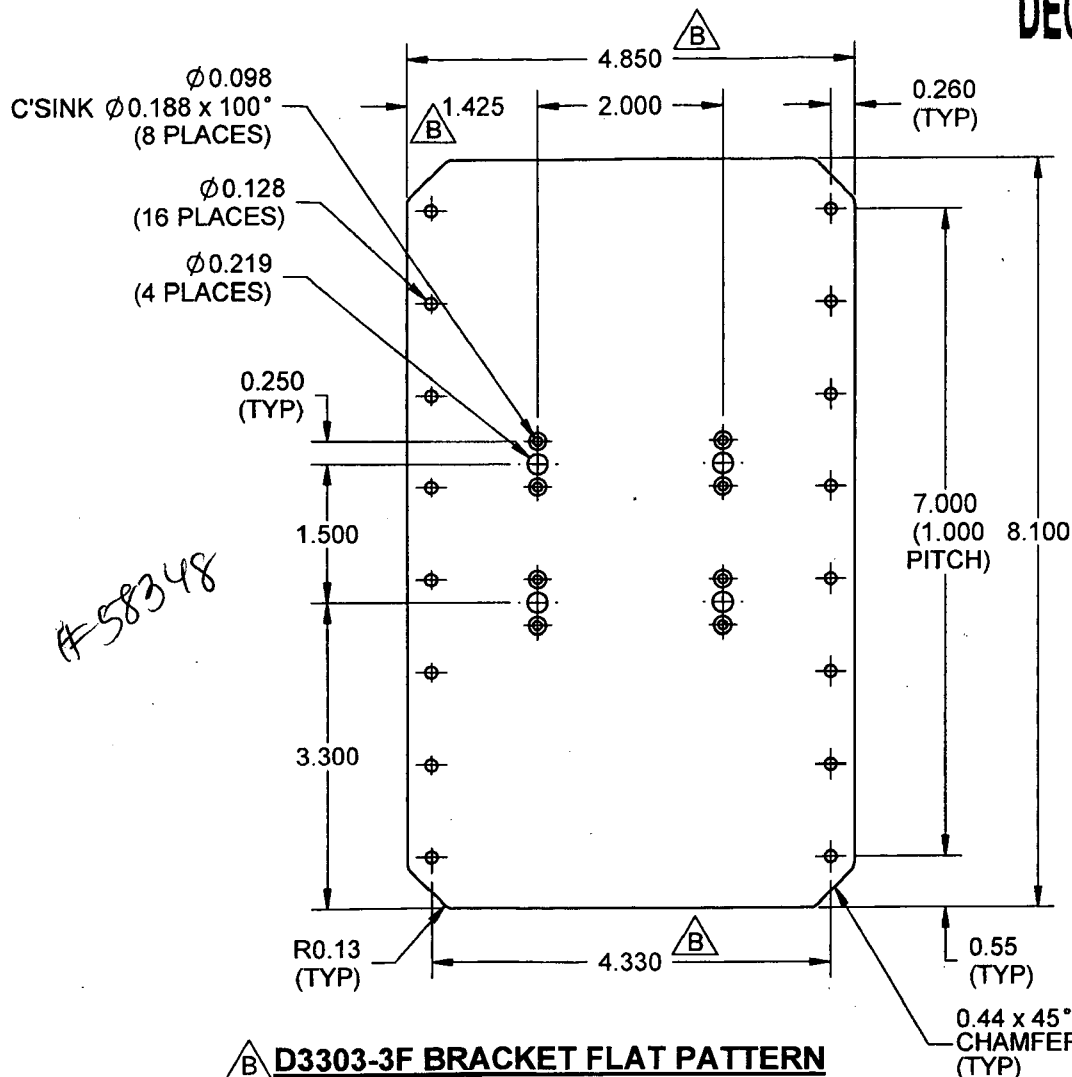
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

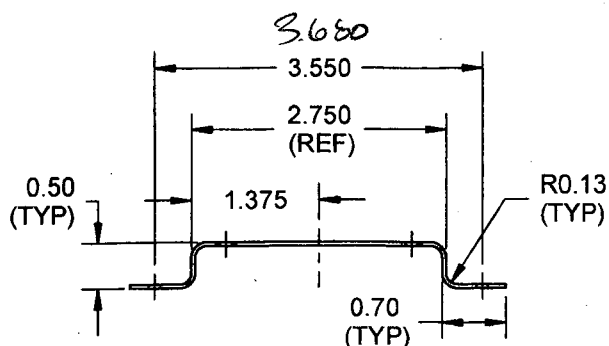
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

DEO ATTACHED

RELEASED
06.09.19

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries